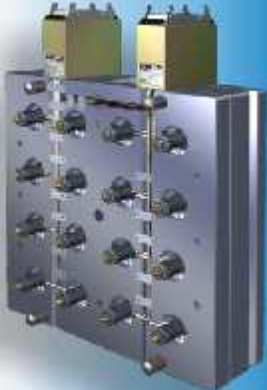


ORYCON

COMPLETE HOT HALVES



Center Gating



Mini-Cluster



**Hot Tunnel Gating
Hybrid**

ORYCON

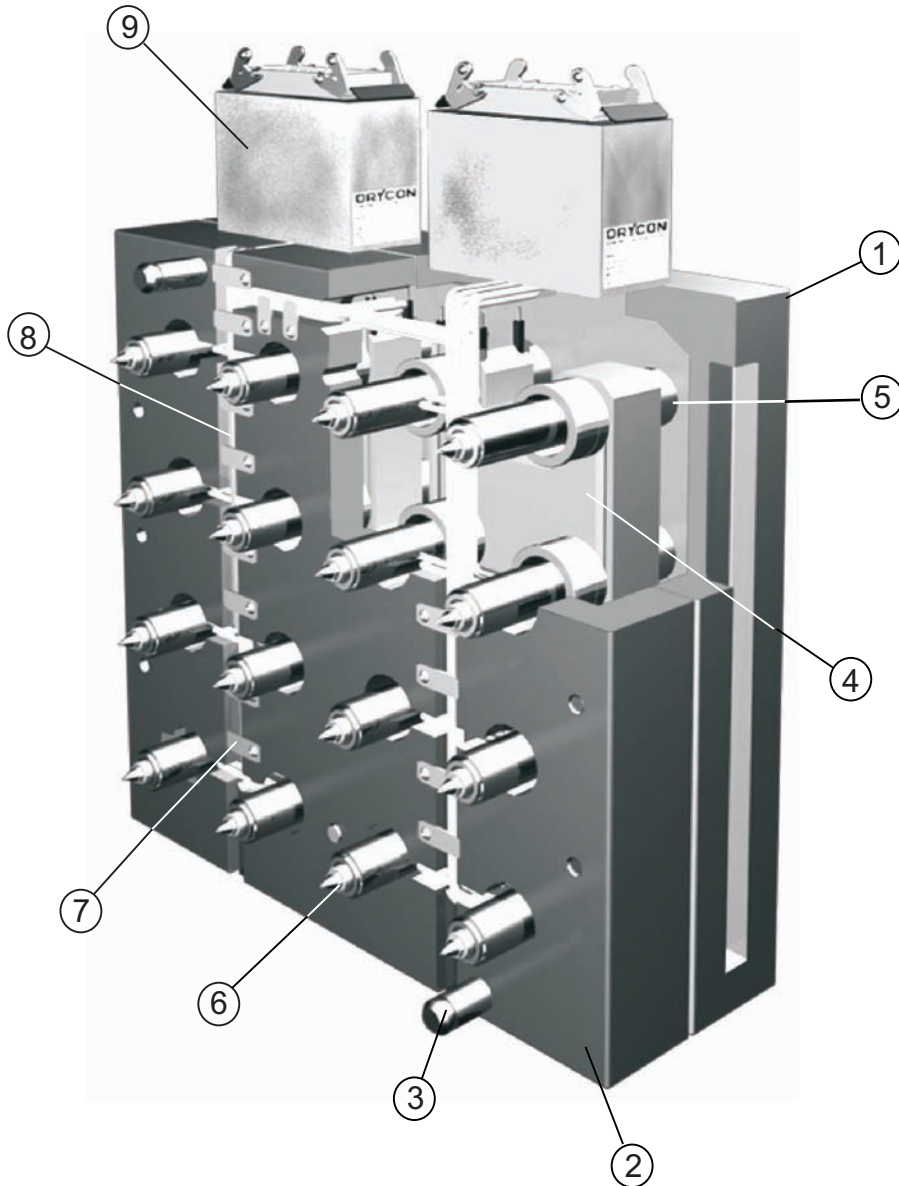
Dedicated To Your Success

COMPLETE HOT HALVES

COMPLETE HOT HALF ASSEMBLIES

Complete assemblies are supplied wired, tested and ready to be mounted on the cavity plates of the mold. ORYCON HOT HALVES can cut delivery times, cut costs and increase shop efficiency by allowing Mold Makers to concentrate on their specialty work.

Each HOT HALF ASSEMBLY includes:



- 1 - Rear Plate
 - 2 - Retaining Plate
- } AISI 4140 Standard
Options:
Nickel Plating
AISI 420 Stainless

- 3 - Leader Pins
- 4 - Manifold
- 5 - Manifold Spacers
- 6 - Gating Bushings
- 7 - Wire Clamps
- 8 - Wiring
- 9 - Mold Junction Box(es) with connectors to customer's specs

- Water Testing
- Electrical Testing
- Run testing of 3 cycles of heating and cooling before shipping

Complete Hot Halves

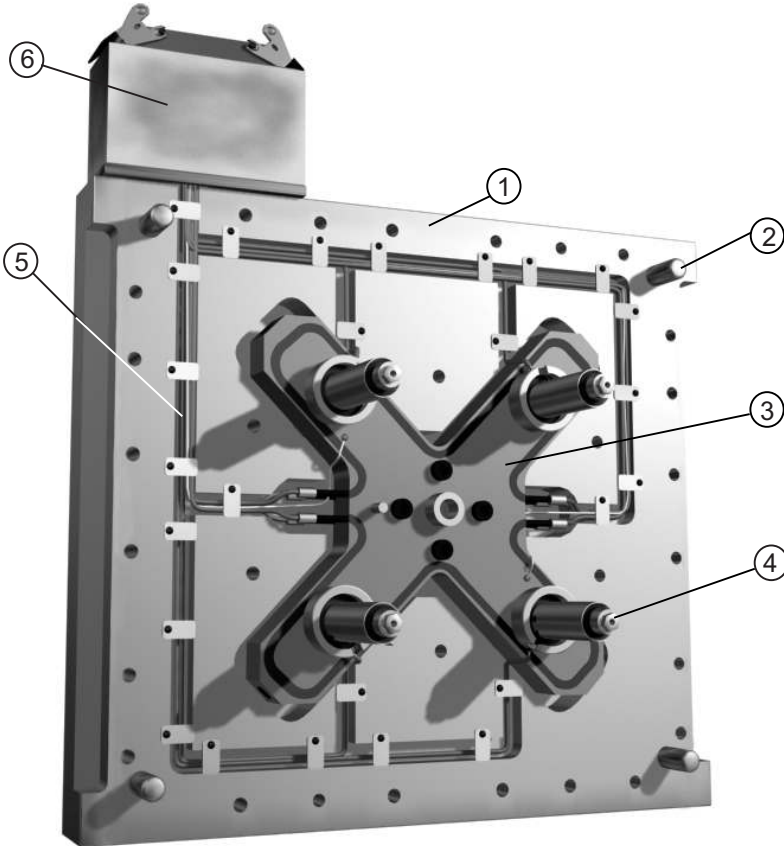
FOR QUOTATION PLEASE SPECIFY:

- _____ • Mold Base W x H
- _____ • Mold Base Material
- _____ • Dimension from Gate to Back of Cavity Plate
- _____ • Number of Cavities

- _____ • Centerlines of Cavities
- _____ • Resin to be Molded
- _____ • Estimated Weight of Part or Part Print if Available

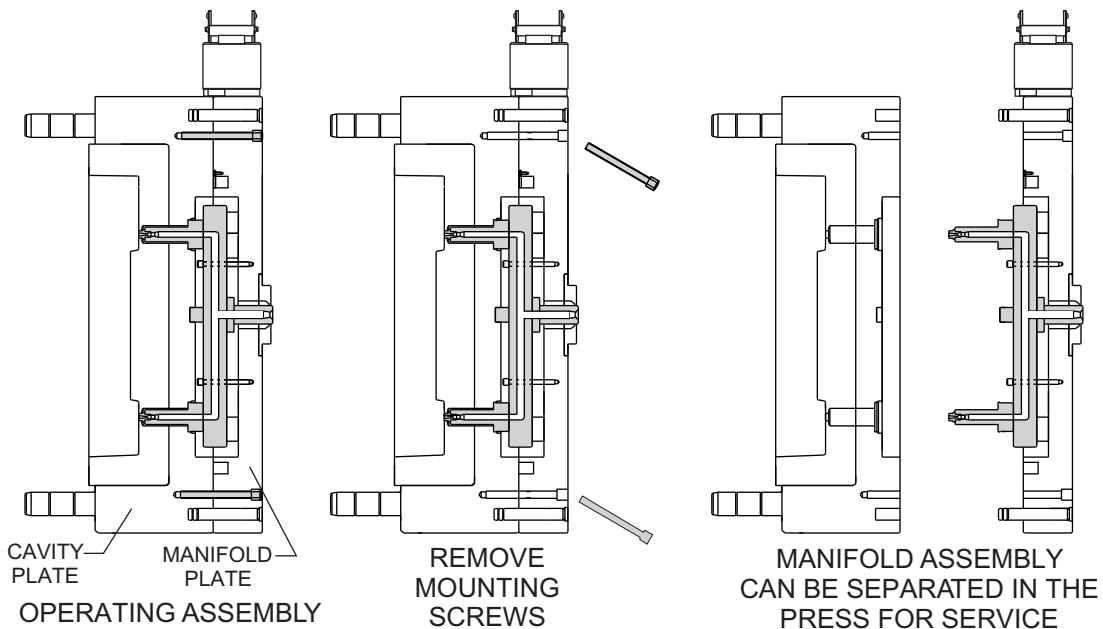
SINGLE PLATE ASSEMBLY FOR LEAK-PROOF INTEGRAL MANIFOLD SYSTEM

Single Plate Assemblies are a cost-effective alternative to a full hot half which is made possible by the design of the Leak-Proof Manifold System. They are supplied wired, tested and ready to be mounted to the cavity plate of the mold. ORYCON SINGLE PLATE ASSEMBLIES can cut delivery times, cut costs and increase shop efficiency by allowing Mold Makers to concentrate on their specialty work. For customers who prefer to machine their own plates, detailed designs can be supplied as an option.



Each SINGLE PLATE ASSEMBLY includes:

- 1 - Clamp Plate
- 2 - Leader Pins
- 3 - Manifold
- 4 - Nozzles
- 5 - Wiring
- 6 - Mold Junction Box(es) with connectors to customer's specs
- Water Testing
- Electrical Testing
- Run testing of 3 cycles of heating and cooling before shipping



MINIATURE CLUSTER HOT HALF ASSEMBLIES

Miniature Cluster Hot Half Assemblies are designed for high cavitation, miniature parts. They offer individual tip control and are supplied ready to be mounted to the cavity plate of the mold.



Each MINIATURE CLUSTER HOT HALF ASSEMBLY includes:

- 1 -Rear Plate
- 2 - Retaining Plate
- 3 - Leader Pins
- 4 - Manifold
- 5 - Miniature Clusters
- 6 - Mold Junction Box(es)
with connectors to
customer's specs

AISI 4140 Standard
Options:
Nickel Plating
AISI 420 Stainless

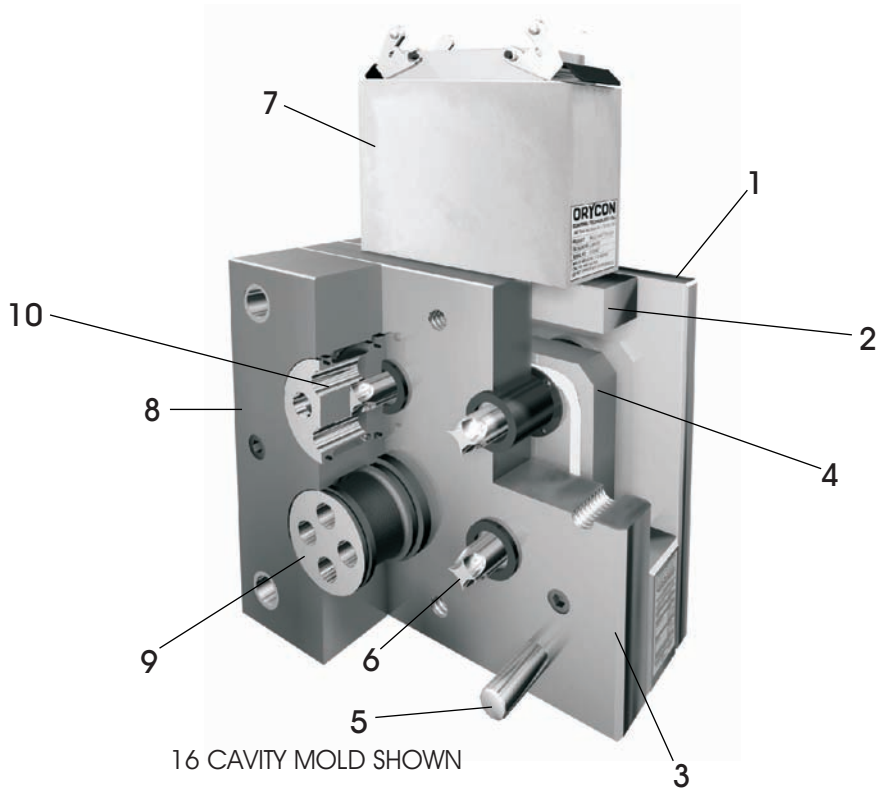
- Water Testing
- Electrical Testing
- Run testing of 3 cycles
of heating and cooling
before shipping

Complete
Hot Halves

FOR QUOTATION PLEASE SPECIFY:

- | | | | |
|-------|--|-------|--|
| _____ | • Mold Base W x H | _____ | • Number of Clusters |
| _____ | • Mold Base Material
AISI 4140, AISI 420 | _____ | • Centerlines of Cavities |
| _____ | • Dimension from Gate to Back
of Cavity Plate | _____ | • Resin to be Molded |
| _____ | • Number of Cavities | _____ | • Estimated Weight of Part
or Part Print if Available |

HOT TUNNEL GATING HYBRID HOT HALF ASSEMBLIES

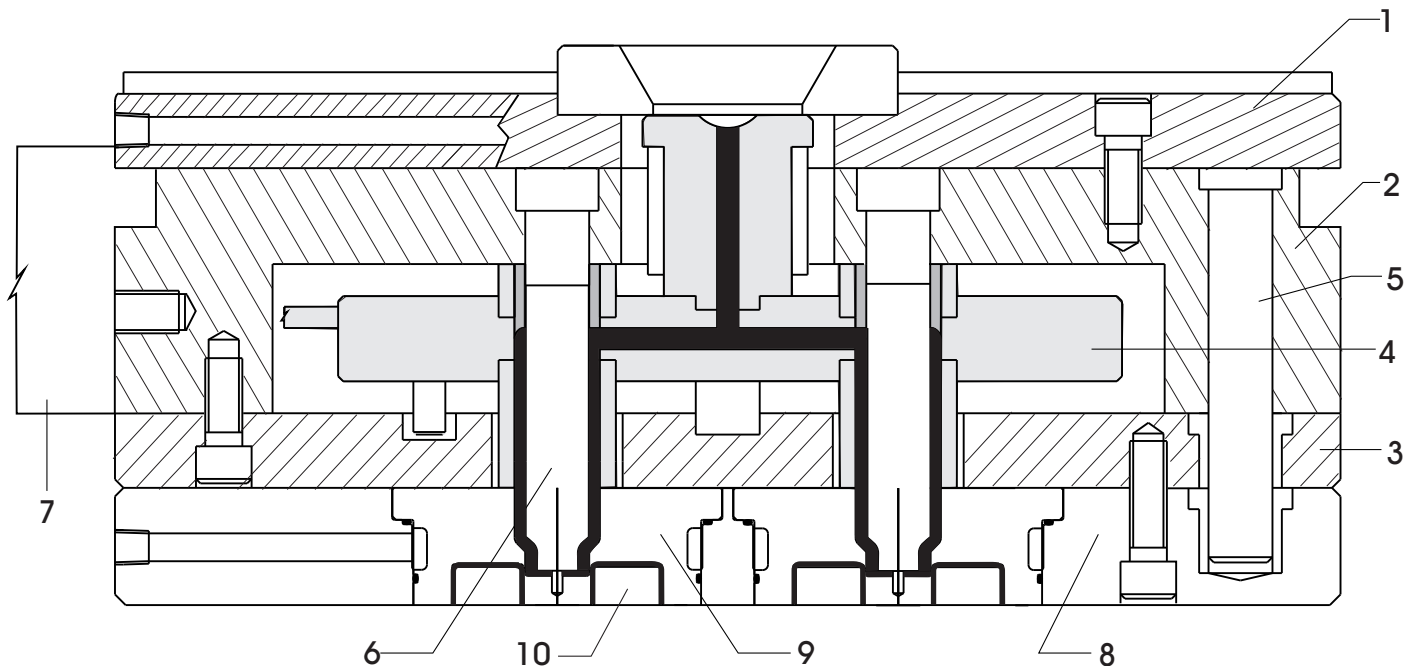


ORYCON Hybrid Hot Tunnel Gating Systems combine the advantages of externally heated manifolds with internally heated integral torpedoes. Because the torpedoes' heating resistance coils can be located at the optimum point, the recovery time is extremely fast. The mold cooling can be maximized and the cycle times can be reduced practically to the injection molding press limits. Hybrid Hot Tunnel Gating Systems are an economical alternative for high cavitation part molding. ORYCON's Hot Tunnel Gating Systems are producing millions of parts in many different sectors of the plastics industry.

- | | | | |
|---------------------|---------------------------------|---------------------------|-------------------|
| 1 - Clamp Plate | 4 - Manifold | 7 - Mold Junction Box(es) | 8 - Cavity Plate |
| 2 - Spacer Plate | 5 - Leader Pins (4) | with connectors to | 9 - Cavity Insert |
| 3 - Retaining Plate | 6 - Integrally Heated Torpedoes | customer's specs | 10 - Cavity |

Each Hybrid Hot Half Assembly includes:

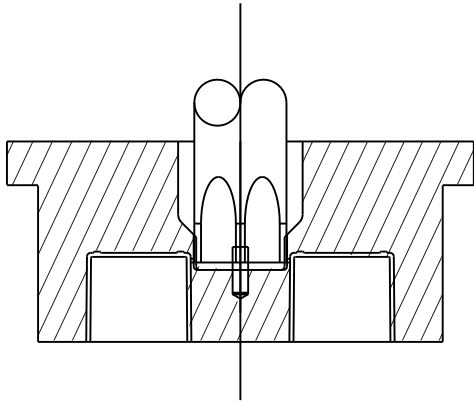
- Electrical Testing
- Water Testing
- Run testing of 3 cycles of heating and cooling before shipping



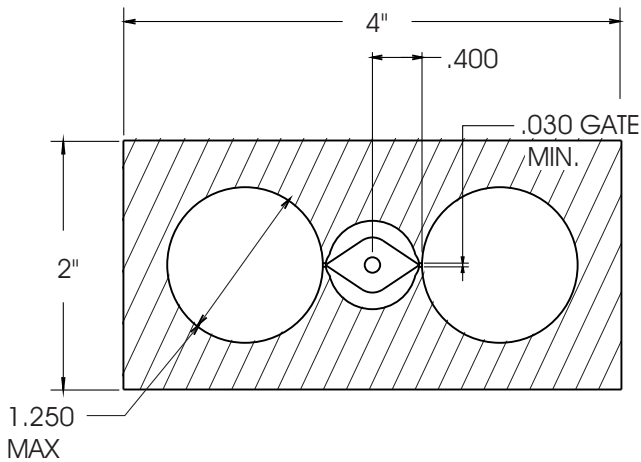
HOT TUNNEL GATING HYBRID HOT HALF GATING CONFIGURATIONS

LAYOUT REQUIREMENTS

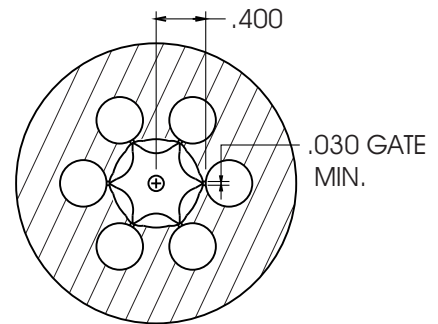
1. Cavities must be located *tangent* to a radius $.400''$ from the centerline of the cluster.
2. Cavity size should not exceed approx. $1.250''$ Diameter. Cavity shape may vary from round to square to irregular.
3. Maximum part weight 2.5 grams.
4. Maximum gate diameter is $.055''$ (1.40mm)
5. Resins best suited:
Polystyrene, Polyethylene, Polypropylene.



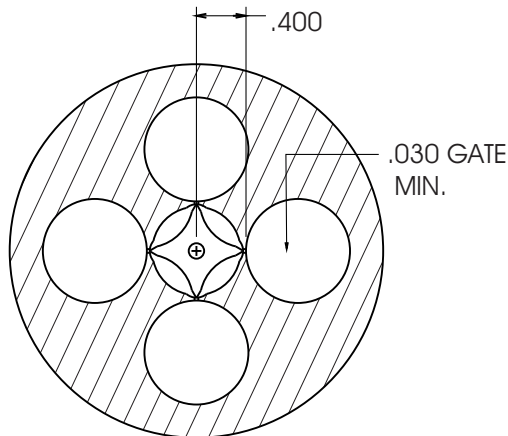
GATE INSERT
(NO COOLING SHOWN)



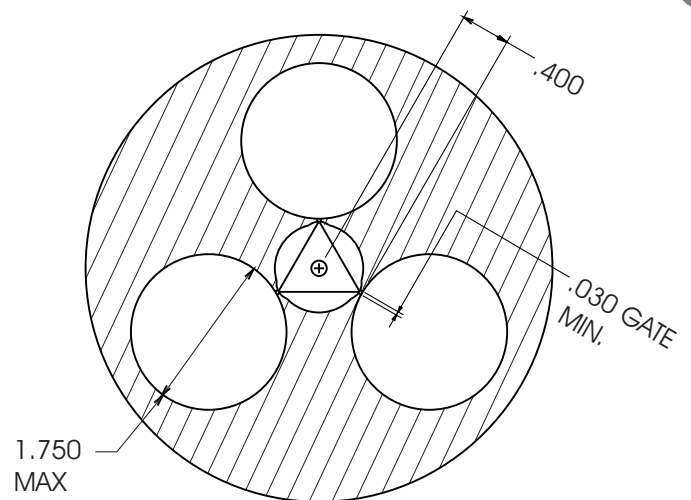
2 CAVITY INSERT



6 CAVITY INSERT

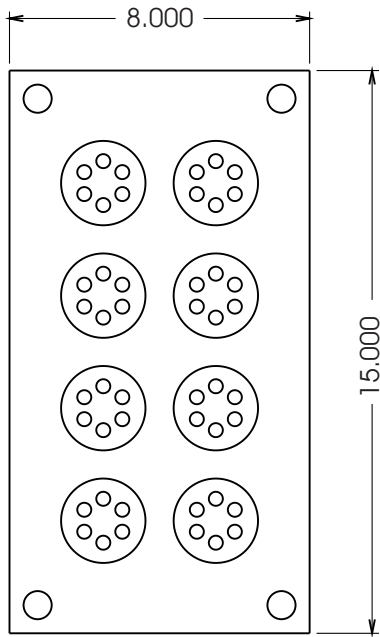


4 CAVITY INSERT

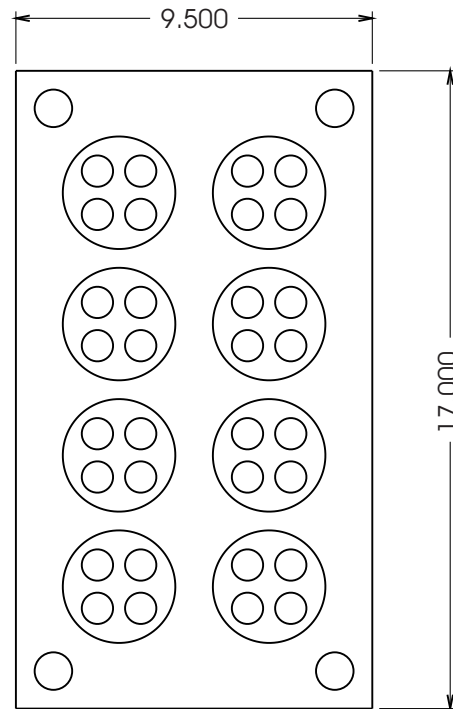


3 CAVITY INSERT

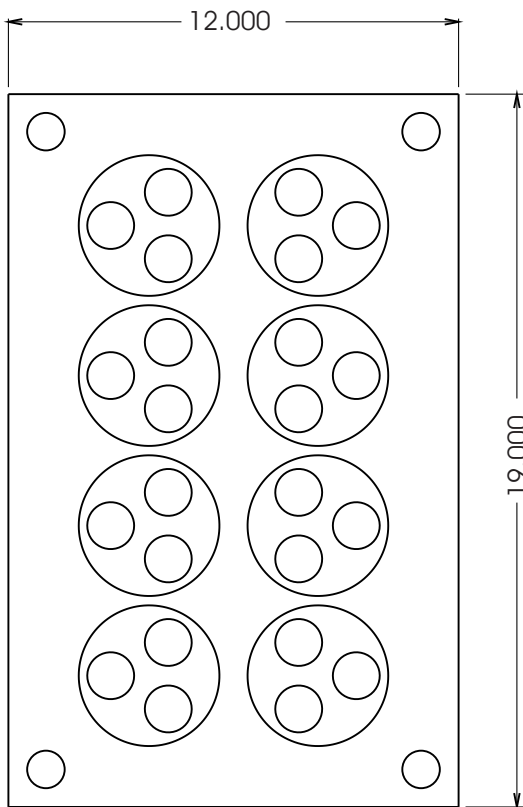
HOT TUNNEL GATING HYBRID HOT HALF MOLD LAYOUT EXAMPLES



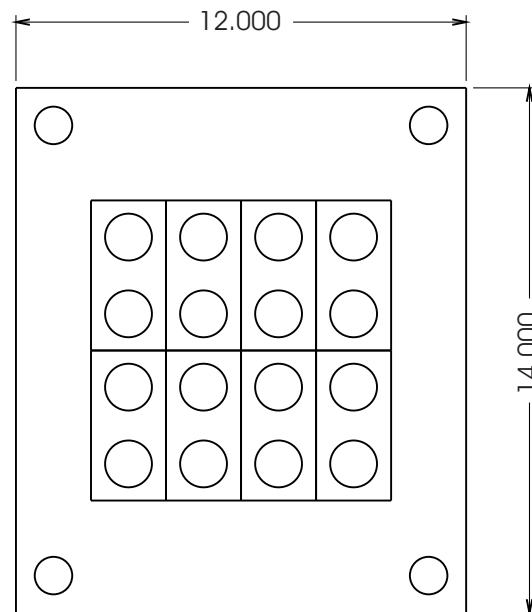
PART DIA.: .375
NO. OF CAVITIES: 48
NO. OF DROPS: 8



PART DIA.: .830
NO. OF CAVITIES: 32
NO. OF DROPS: 8



PART DIA.: 1.240
NO. OF CAVITIES: 24
NO. OF DROPS: 8



PART DIA.: 1.250
NO. OF CAVITIES: 16
NO. OF DROPS: 8

For design details and quotations contact ORYCON.